






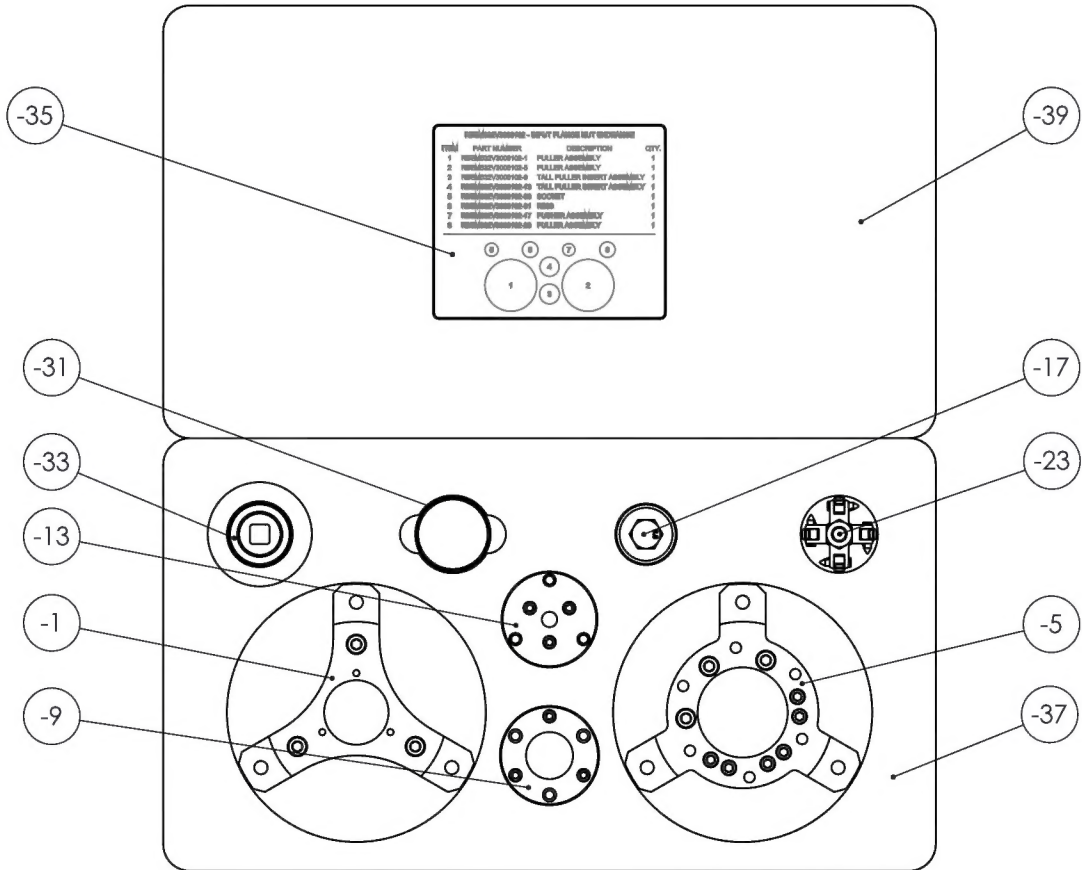


This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	1/5/2016	DPD	JAG
2	16-0181	-3 ADDED DIM Ø6.686. ADDED  TO DIMS 3X M5X0.8, 3X M8X1.25, AND 3X Ø.350 THRU. -7 ADDED  TO DIMS 6X Ø280, 3X M8X1.25, 6X M6X1.0, AND 3X Ø.350 THRU. -11 ADDED  TO DIMS 3X M5X0.8 AND 3X Ø.230 THRU ALL  Ø.35  .17. CH'D DIM WAS Ø1.181 THRU ALL IS Ø1.2280/1.2245 THRU ALL (S.F. -33). -15 ADDED  TO DIMS 3X M5X0.8, M12X1.75, AND 3X Ø.228 THRU ALL  Ø.33 X 90°. -19 CH'D MATERIAL WAS DELRIN IS WHITE DELRIN/ACETAL. -21 CH'D P/N WAS MCMMASTER-CARR #91280A722 IS MSC #09657693. ADDED ZINC PLATE FINISH. -11, -15, -25, -27, -29, -33 ADDED HEAT TREAT RC 28-32. -3, -7, -11, -15 CH'D NOTE 2 WAS PAINT IS POWDER COAT. -33 CH'D DIM WAS Ø1.18 IS Ø1.180/1.178 (S.F. -11). -37 & -39 CH'D MATERIAL & VENDOR WAS Y20 BLACK (I.R. SPECIALTY) IS ETHAFOAM 220, BLACK (CASE SOLUTIONS). -37 DELETED DIM 4X R.69 ADDED DIM'S 4X 45°. 4X .75. -39 DELETED DIM 4X R.69, ADDED DIM'S 4X .75, 4X 45°, 2X .28, 1.65. -51 ADDED DRAWING FOR MODIFIED BUYOUT.	10/20/2016	RJC	SM

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
					X		-1	1	PULLER ASSEMBLY			2
					1		-3		PULLER	6061		3
				X			-5	1	PULLER ASSEMBLY			4
				1			-7		PULLER	6061		5
			X				-9	1	TALL PULLER INSERT ASSEMBLY			6
			1				-11		PULLER CENTER	4140/4142		7
		X					-13	1	TALL PULLER INSERT ASSEMBLY			8
		1					-15		PULLER CENTER	4140/4142		9
	X						-17	1	PUSHER ASSEMBLY			10
	1						-19		PUSHER	WHITE DELRIN/ACETAL		11
	1						-21		HEX HEAD CAP SCREW	STEEL	M12 X 1.75 X 45mm (MSC #09657693) MODIFIED	12
X							-23	1	PULLER ASSEMBLY			13
1							-25		PULLER BASE	4140/4142		14
4							-27		PULLER ARM	4140/4142		15
1							-29		PULLER SCREW	4140/4142		16
							-31	1	RING	6061		17
							-33	1	SOCKET	4140/4142		18
							-35	1	CONTENTS PLACARD	PLASTIC		19
						B/O	-37	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	5.79 X 11.26 X 20.12 (CASE SOLUTIONS)	20
						B/O	-39	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.79 X 11.26 X 20.12 (CASE SOLUTIONS)	21
				3	3	B/O	-41		SOCKET HEAD CAP SCREW	S.S.	M8 X 1.25 X 30mm (MCMMASTER-CARR #91292A149)	2, 4
				6		B/O	-43		SOCKET HEAD CAP SCREW	S.S.	M6 X 1 X 25mm (MCMMASTER-CARR #91292A138)	4
			3			B/O	-45		SOCKET HEAD CAP SCREW	S.S.	M5 X 0.8 X 12mm (MCMMASTER-CARR #91292A125)	6
		3				B/O	-47		SOCKET HEAD CAP SCREW	S.S.	M5 X 0.8 X 18mm (MCMMASTER-CARR #91292A127)	8
	1					B/O	-49		FLAT HEAD SOCKET CAP SCREW	S.S.	M5 X 0.8 X 16mm (MCMMASTER-CARR #92125A212)	10
4						B/O	-51		CLEVIS PIN	S.S.	Ø3/16 X 3/4, 1/2 USABLE (MCMMASTER-CARR #94411A510) MODIFIED	22
1						B/O	-53		HEX NUT	STEEL	M10 X 1.5 (MCMMASTER-CARR #90591A171)	13
						B/O	-55	1	CASE	PLASTIC	#APP-1510-E	N/S
						B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
ASSY -23	ASSY -17	ASSY -13	ASSY -9	ASSY -5	ASSY -1							

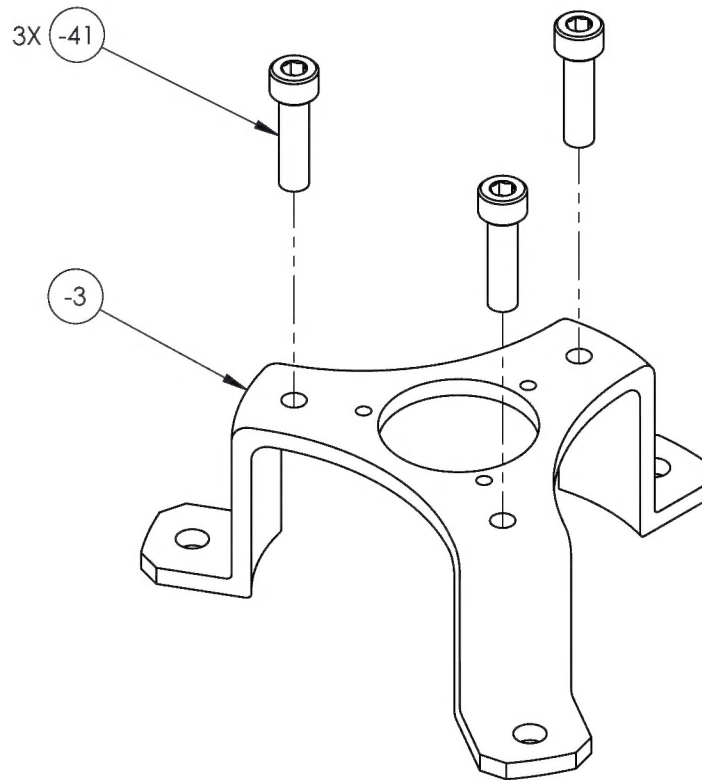


NOTE:
REF. AIRBUS T/N: M632V3006102.

DART AEROSPACE			
TITLE INPUT FLANGE NUT EXCHANGE			
DWG NO. RBEM632V3006102			REV 2
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE 1:5		DATE 12/7/2015	SHEET 1 OF 22

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED




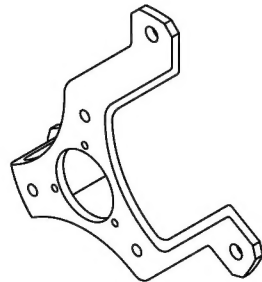
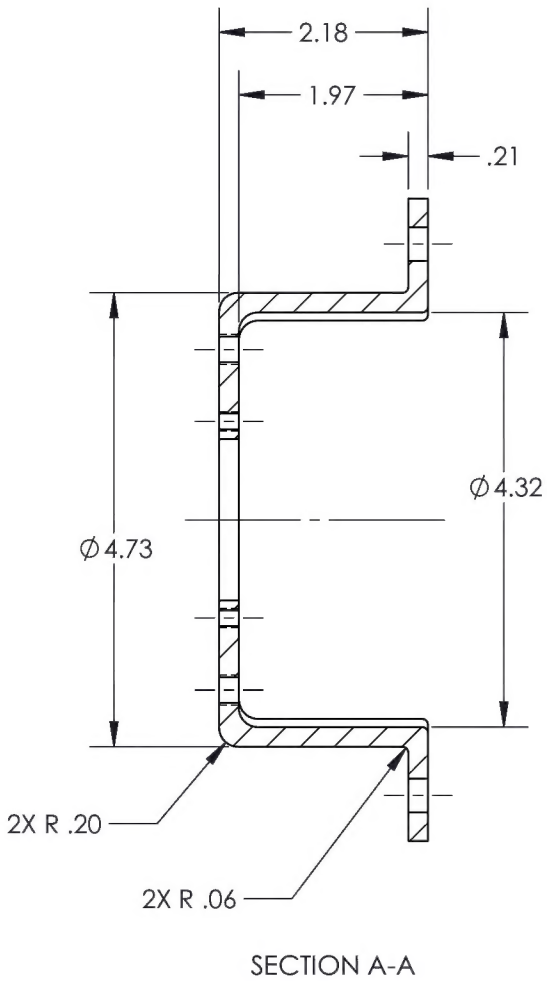
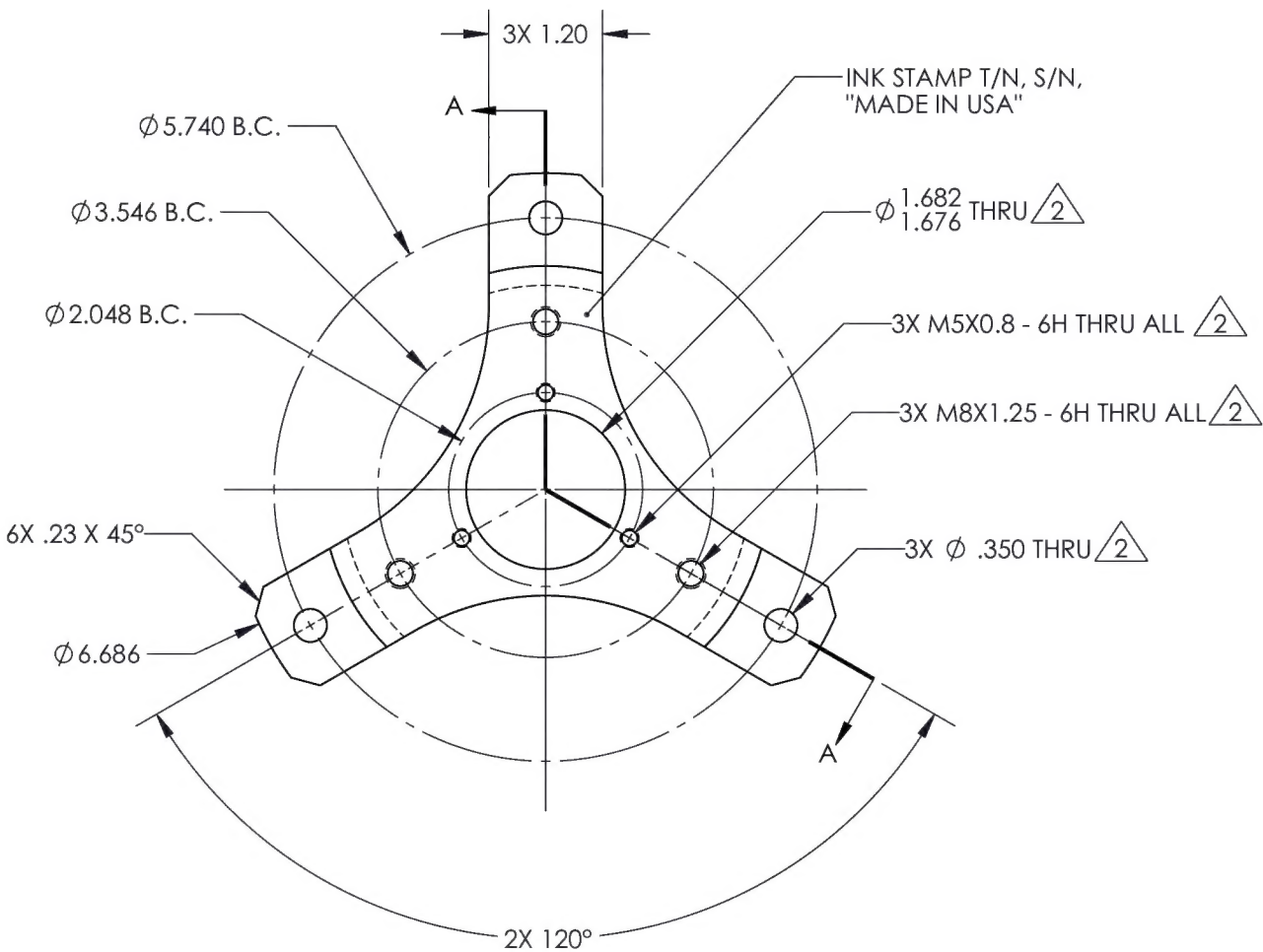
-1


PULLER ASSEMBLY

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-1	REV 2
MAT'L REAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/7/2015
SHEET 2 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-3 ADDED DIM Ø6.686, ADDED  TO DIMS 3X M5X0.8, 3X M8X1.25, AND 3X Ø.350 THRU, CH'D NOTE 2 WAS PAINT IS POWDER COAT.	10/20/2016	RJC	SM



- NOTES:
- DUAL FINISH:
1ST: CLEAR ANODIZE, MIL-A-8625, TYPE II, CLASS I.
2ND: POWDER COAT YELLOW, FED #13538.
 -  NO POWDER COAT THIS SURFACE.
 - USE CAD DATA FOR MANUFACTURE.



TITLE
INPUT FLANGE NUT EXCHANGE

DWG NO. RBEM632V3006102-3 REV 2

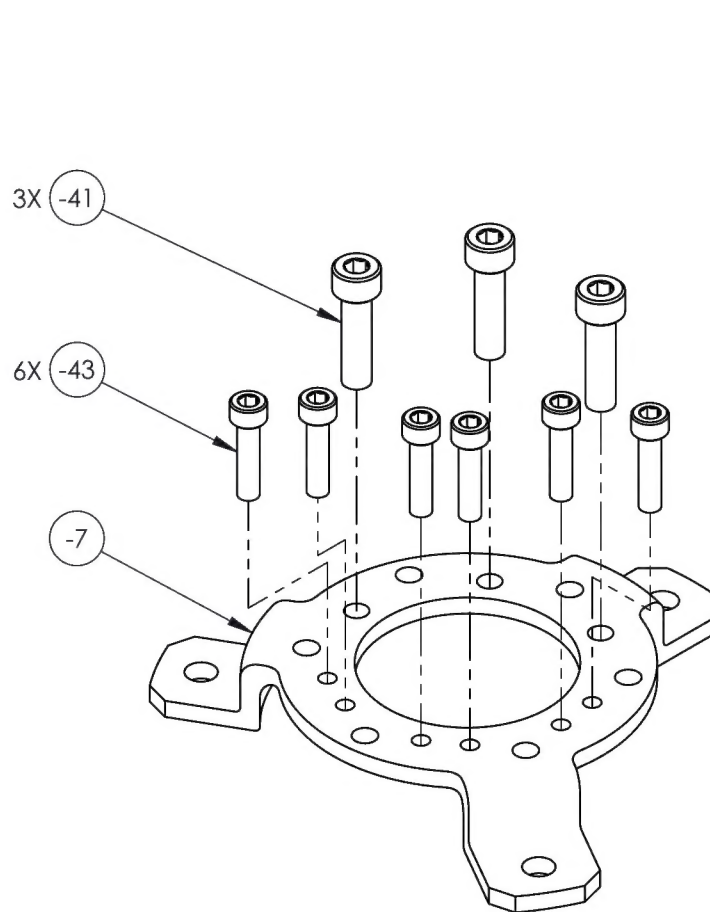
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE NOTE 1	.XX ± .01 ANGLES ±.5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/7/2015
	SHEET 3 OF 22

(-3)

PULLER

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED




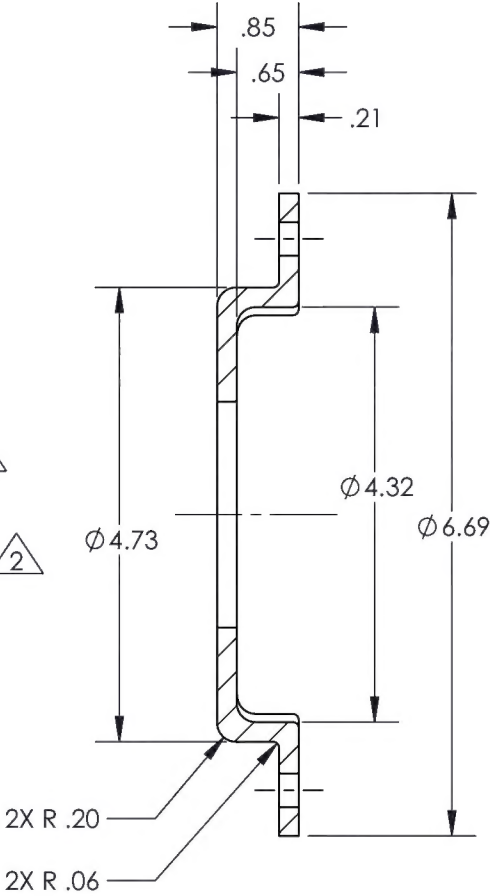
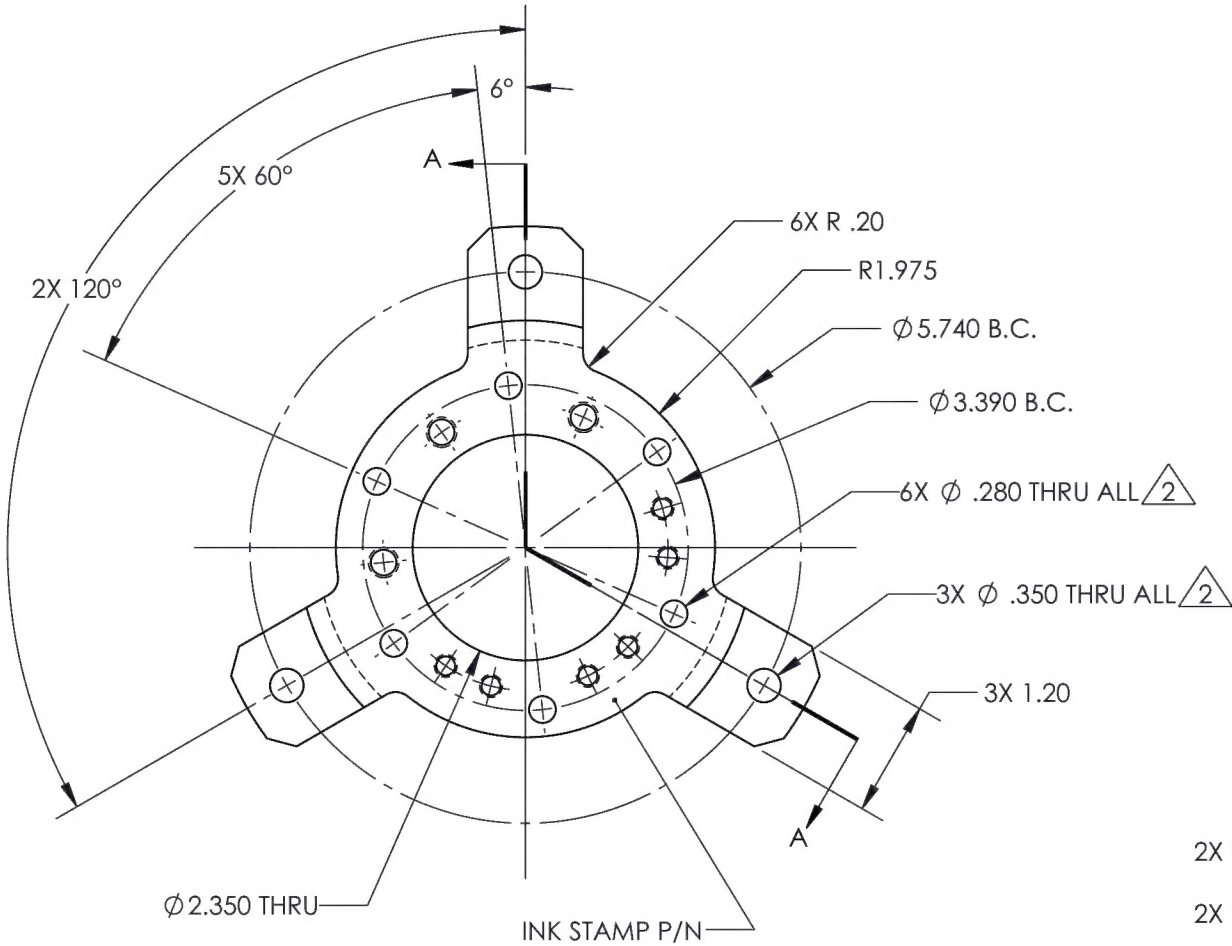
(-5)

PULLER ASSEMBLY

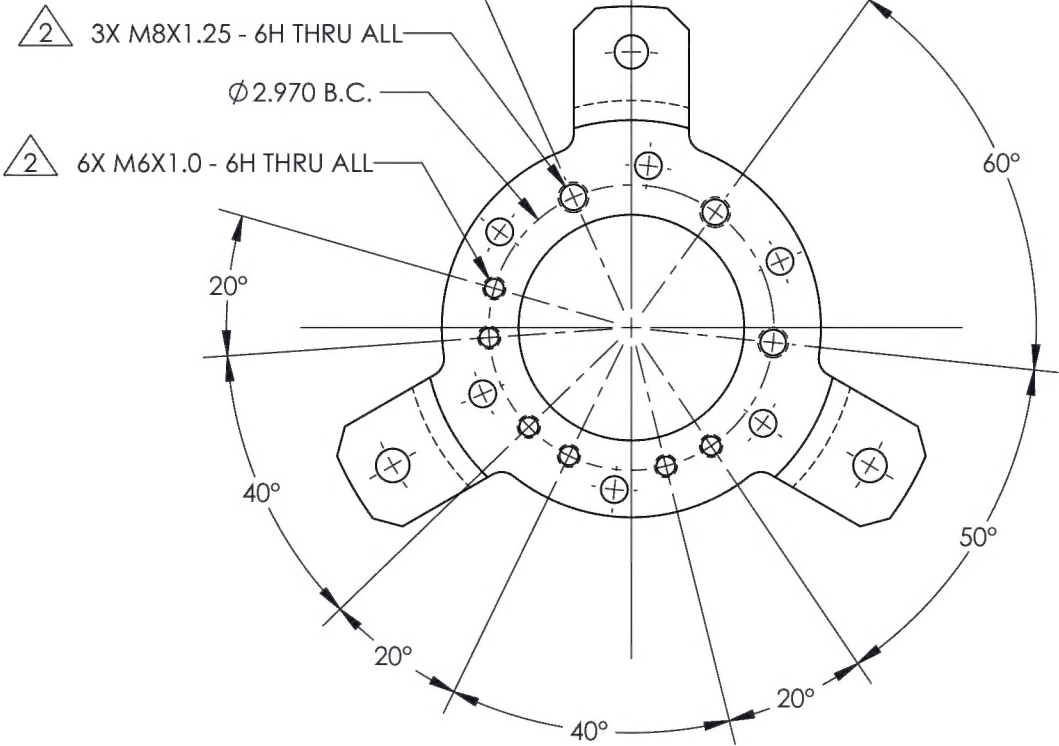
DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-5	REV 2
MAT'L REPT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:2	DATE 12/7/2015
SHEET 4 OF 22	


This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	16-0181	-7 ADDED  TO DIMS 6X Ø280, 3X M8X1.25, 6X M6X1.0, AND 3X Ø.350 THRU, CH'D NOTE 2 WAS PAINT IS POWDER COAT.	10/20/2016	RJC
				SM



SECTION A-A



- NOTE:
- DUAL FINISH:
1ST: CLEAR ANODIZE,
MIL-A-8625, TYPE II, CLASS I.
2ND: POWDER COAT YELLOW, FED # 13538.
 -  NO POWDER COAT THIS SURFACE.
 - USE CAD DATA FOR MANUFACTURE.



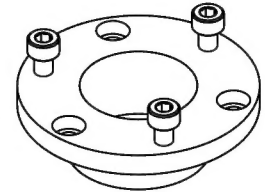
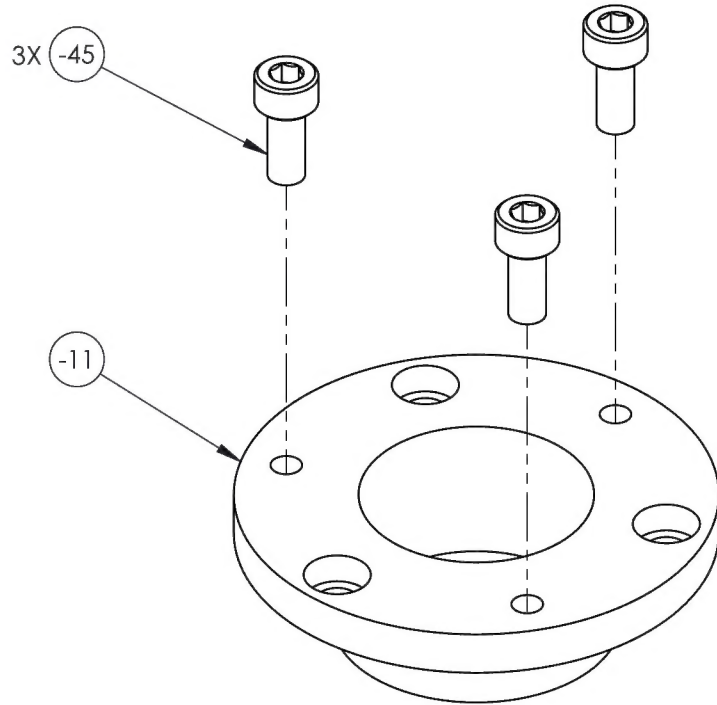
TITLE		
INPUT FLANGE NUT EXCHANGE		
DWG NO. RBEM632V3006102-7		REV 2
MAT'L 6061	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	DIMENSIONS ARE IN INCHES	
FINISH SEE NOTE 1	.XXX ± .005 FRACTIONS ± 1/8	
SPEC	.XX ± .01 ANGLES ± 5°	
	.X ± .1 SURFACES = 125✓	
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES	
CHECKED: MACKOVJAK	.015 x 45° OR .015R	
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY	AFTER PLATING	
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER	
	ASME Y14.5M-2009	
SCALE 1:2	DATE 12/7/2015	SHEET 5 OF 22

-7

PULLER

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



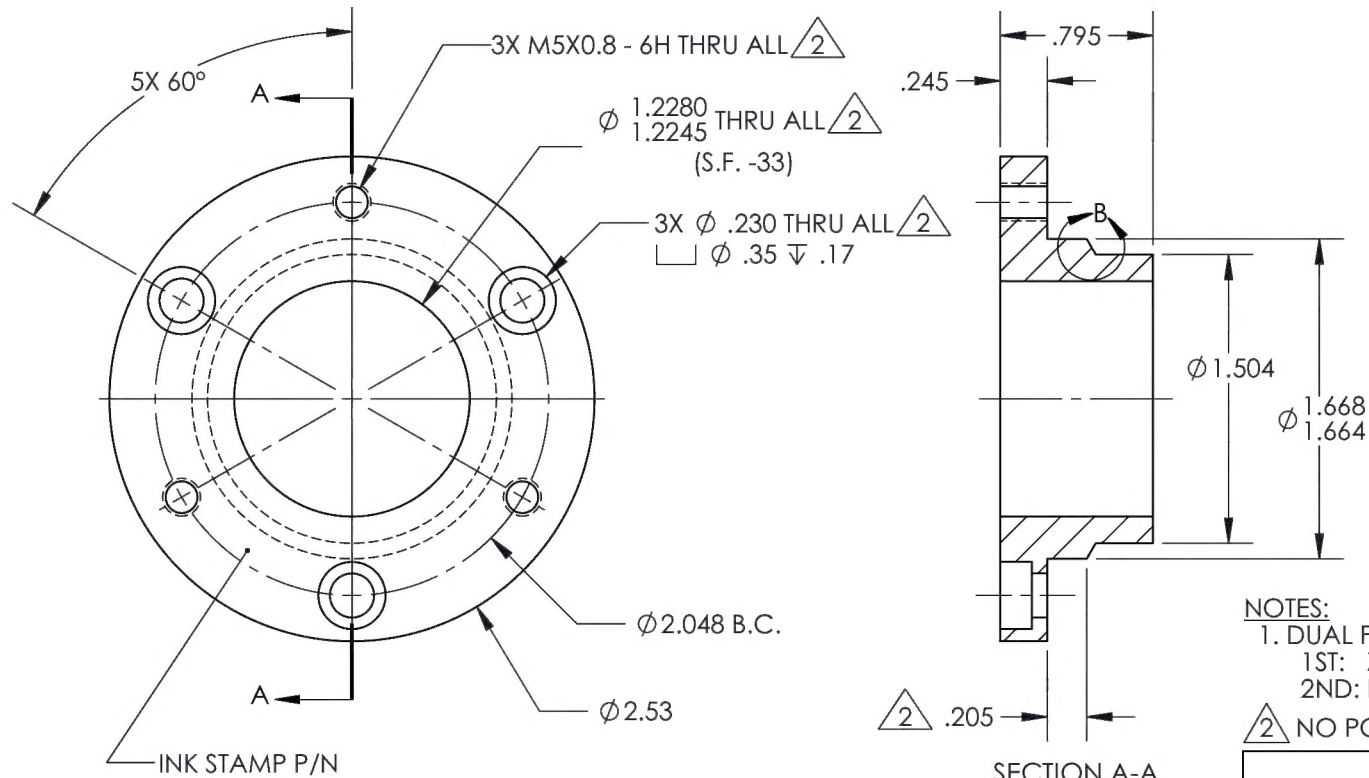
(-9)

TALL PULLER INSERT ASSEMBLY

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-9	REV 2
MAT'L REAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/7/2015
SHEET 6 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-11 ADDED \triangle TO DIMS 3X M5X0.8 AND 3X ϕ .230 THRU ALL \square ϕ .35 ∇ .17, CH'D DIM WAS ϕ 1.181 THRU ALL IS ϕ 1.2280/1.2245 THRU ALL (S.F. -33), ADDED HEAT TREAT RC28-32, CH'D NOTE 2 WAS PAINT IS POWDER COAT.	10/20/2016	RJC	SM



- NOTES:
- DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE I SC2.
2ND: POWDER COAT YELLOW, FED # 13538.
 - NO POWDER COAT THIS SURFACE.

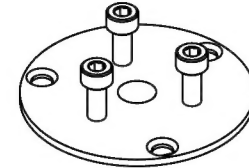
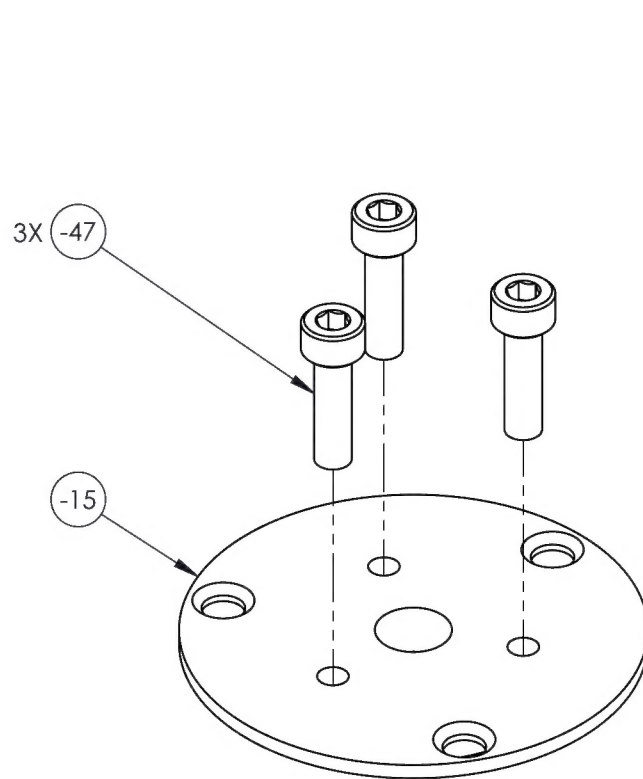
DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-11	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 28-32	.XXX \pm .005 FRACTIONS \pm 1/8
FINISH SEE NOTE 1	.XX \pm .01 ANGLES \pm 5°
SPEC	.X \pm .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/7/2015
SHEET 7 OF 22	

(11)

PULLER CENTER

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED





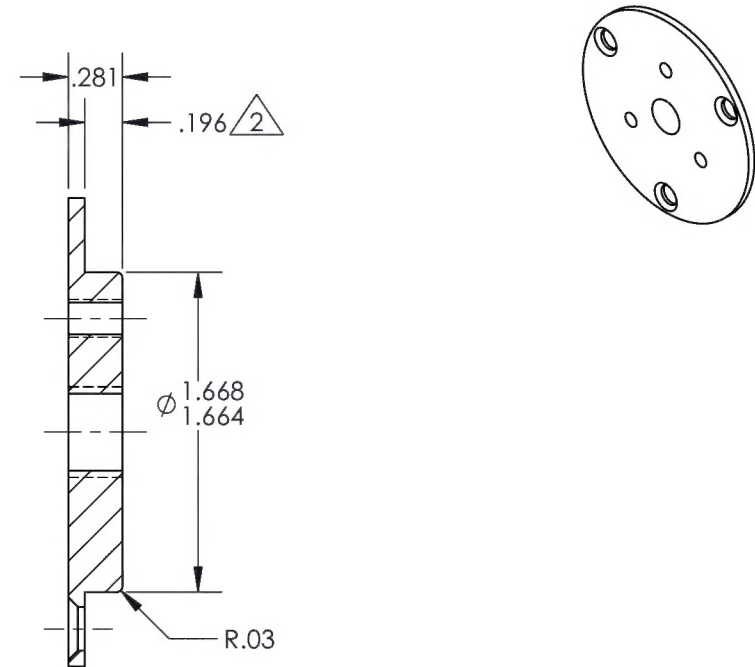
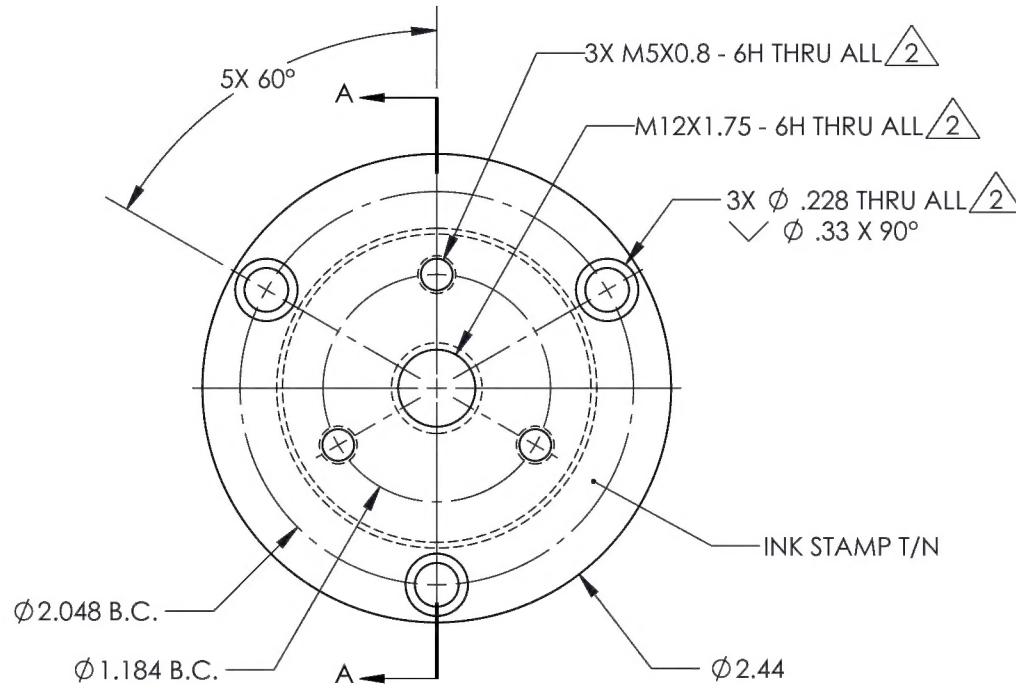
(-13)

TALL PULLER INSERT ASSEMBLY

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-13	REV 2
MAT'L REPT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/7/2015
SHEET 8 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-15 ADDED  TO DIMS 3X M5X0.8, M12X1.75, AND 3X Ø.228 THRU ALL  Ø 33 X 90°. ADDED HEAT TREAT RC 28-32, CH'D NOTE 2 WAS PAINT IS POWDER COAT.	10/20/2016	RJC	SM



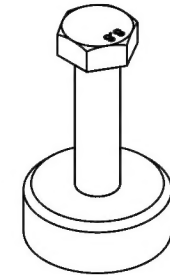
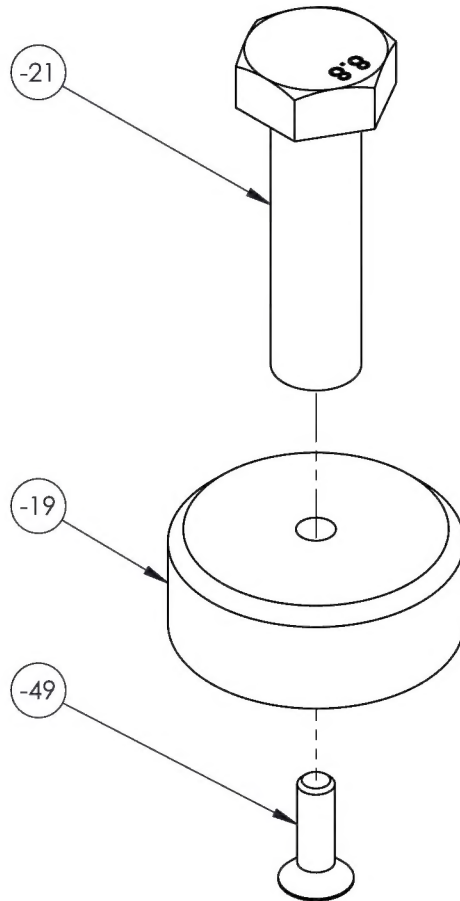
- NOTES:
- DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE I SC2.
2ND: POWDER COAT YELLOW, FED # 13538.
 - \triangle 2 NO POWDER COAT THIS SURFACE.

(-15)
PULLER CENTER

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-15	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH SEE NOTE 1	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: DUERFELDT	.X \pm .1 SURFACES = 125 \checkmark
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 12/7/2015	H175
SHEET 9 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



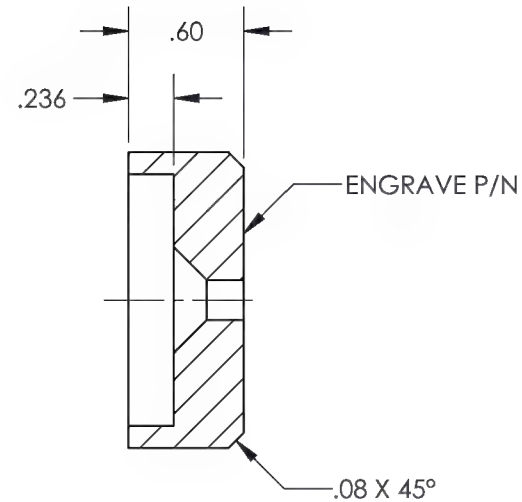
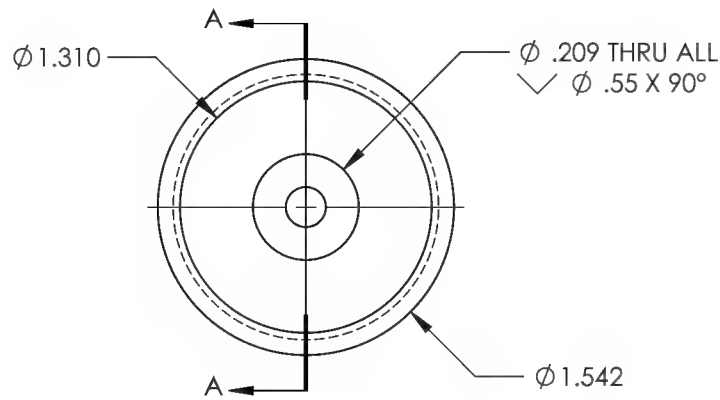
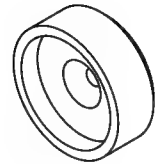
(-17)

PUSHER ASSEMBLY

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-17	REV 2
MAT'L FEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/7/2015
SHEET 10 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-19 CH'D MATERIAL WAS DELRIN IS WHITE DELRIN/ACETAL.	10/20/2016	RJC	SM



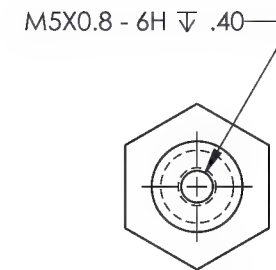
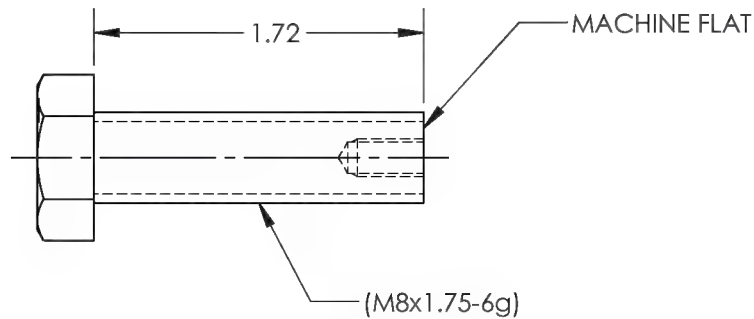
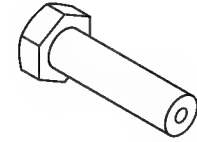
SECTION A-A

(-19)
PUSHER

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-19	REV 2
MAT'L WHITE DELRIN/ACETAL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 12/7/2015
	SHEET 11 OF 22

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-21 CH'D P/N WAS MCMASTER-CARR #91280A722 IS MSC #09657693, ADDED ZINC PLATE FINISH.	10/20/2016	RJC	SM



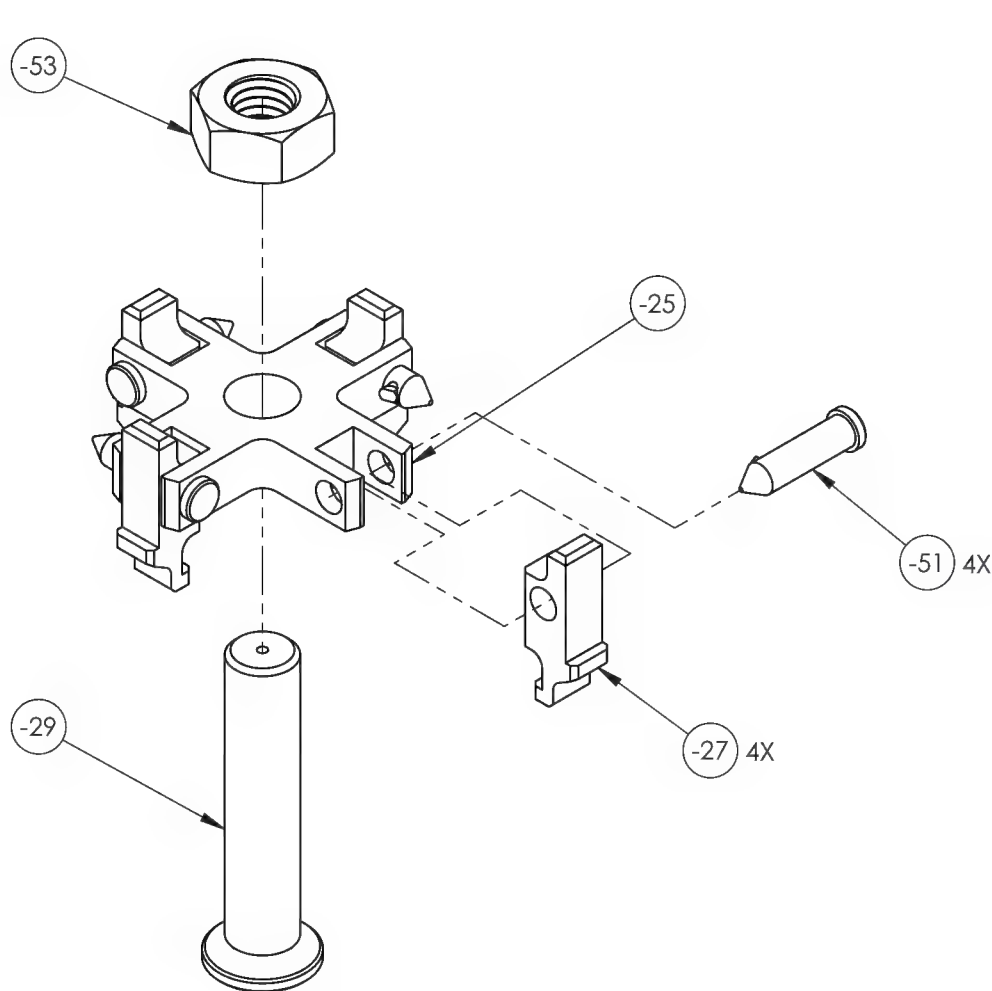
(-21)

HEX HEAD CAP SCREW

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-21	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 12/7/2015	USED ON MODEL
SHEET 12 OF 22	H175

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

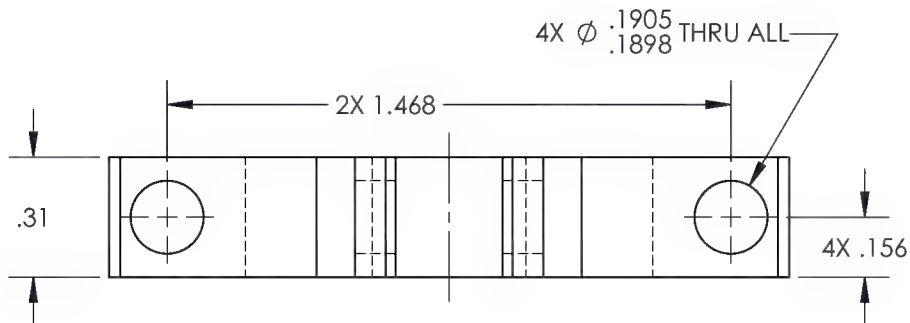
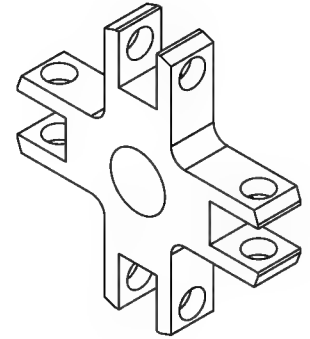
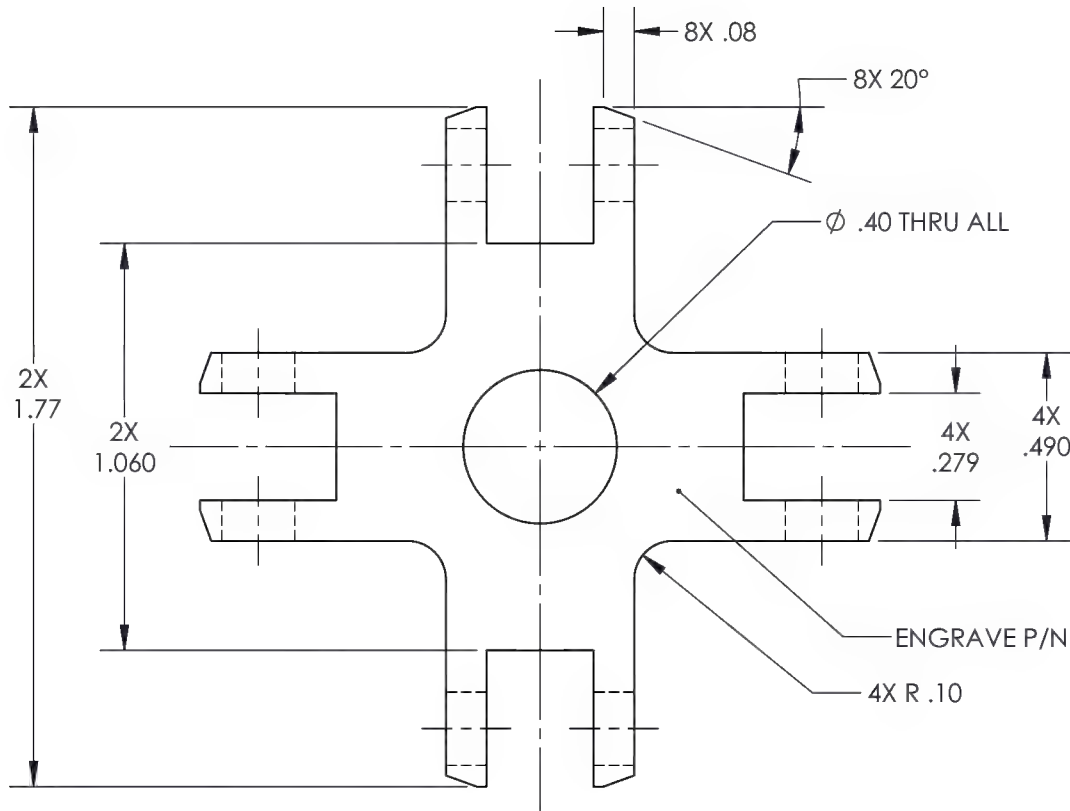


(-23)
PULLER ASSEMBLY

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-23	REV 2
MAT'L FEAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/7/2015
SHEET 13 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-25 ADDED HEAT TREAT RC 28-32.	10/20/2016	RJC	SM

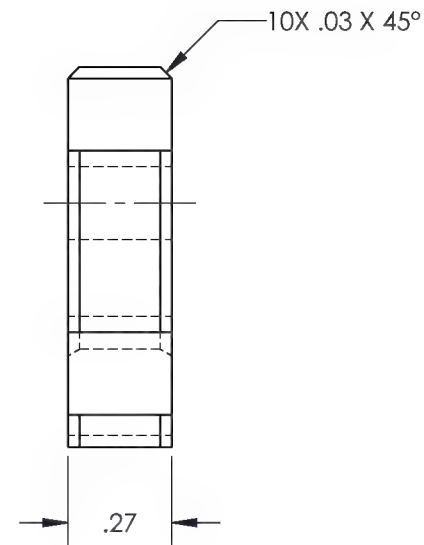
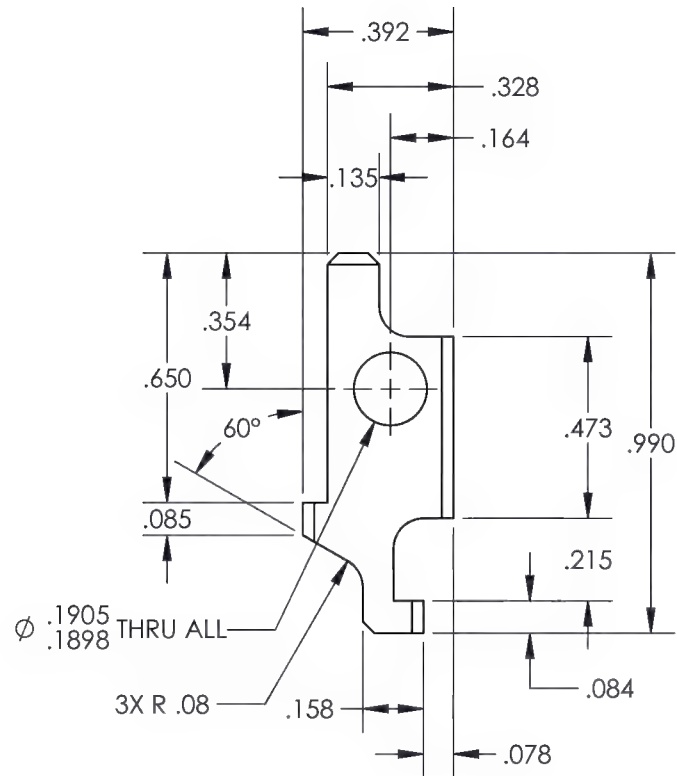


(-25)
PULLER BASE

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-25	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 12/7/2015	USED ON MODEL
SHEET 14 OF 22	H175

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-27 ADDED HEAT TREAT RC 28-32.	10/20/2016	RJC	SM



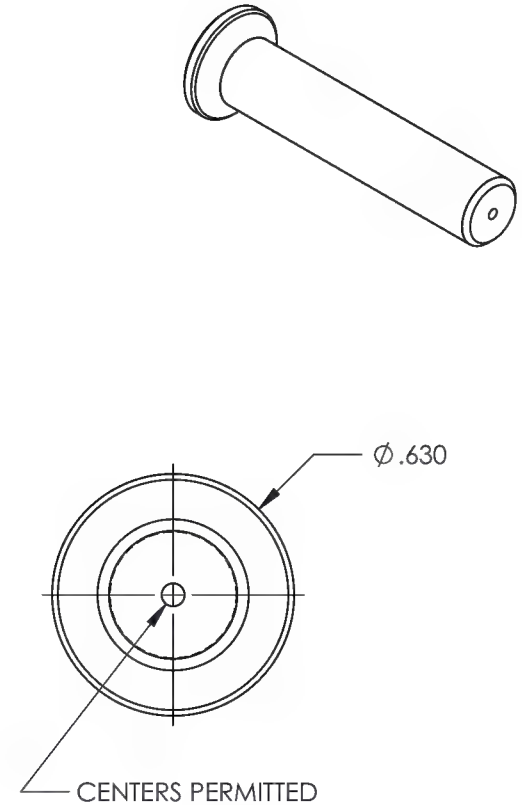
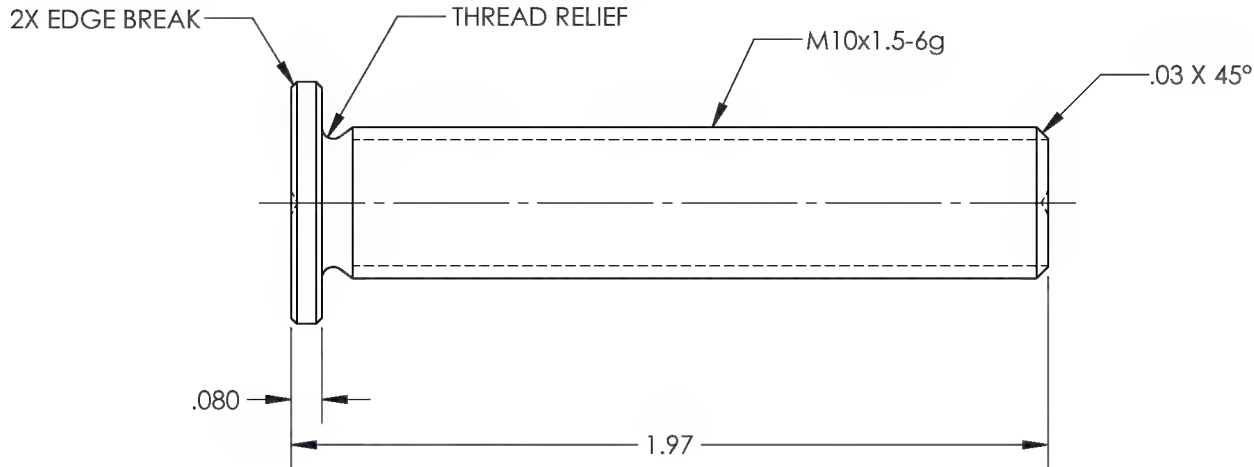
(-27)

PULLER ARM

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-27	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 12/7/2015
	SHEET 15 OF 22

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-29 ADDED HEAT TREAT RC 28-32.	10/20/2016	RJC	SM

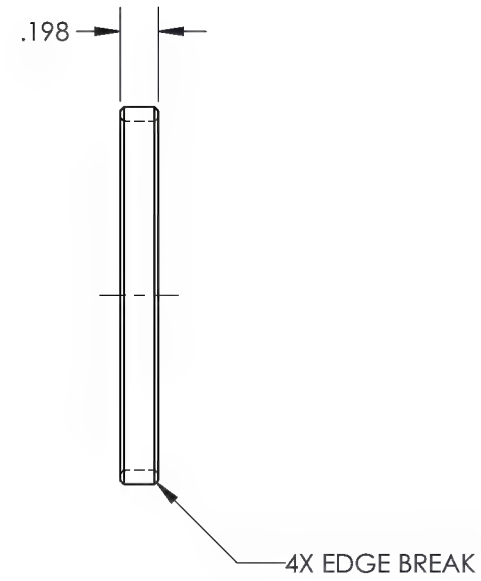
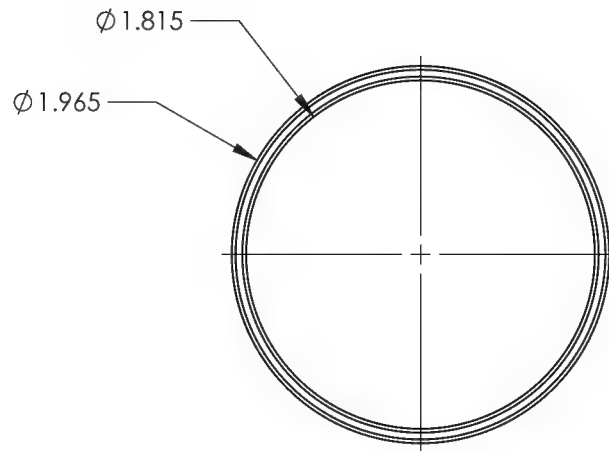


(-29)
PULLER SCREW

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-29	REV 2
MAT'L 4140/4142 HEAT TREAT RC 28-32 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT CHECKED: MACKOVJAK OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	DATE 12/7/2015
SHEET 16 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

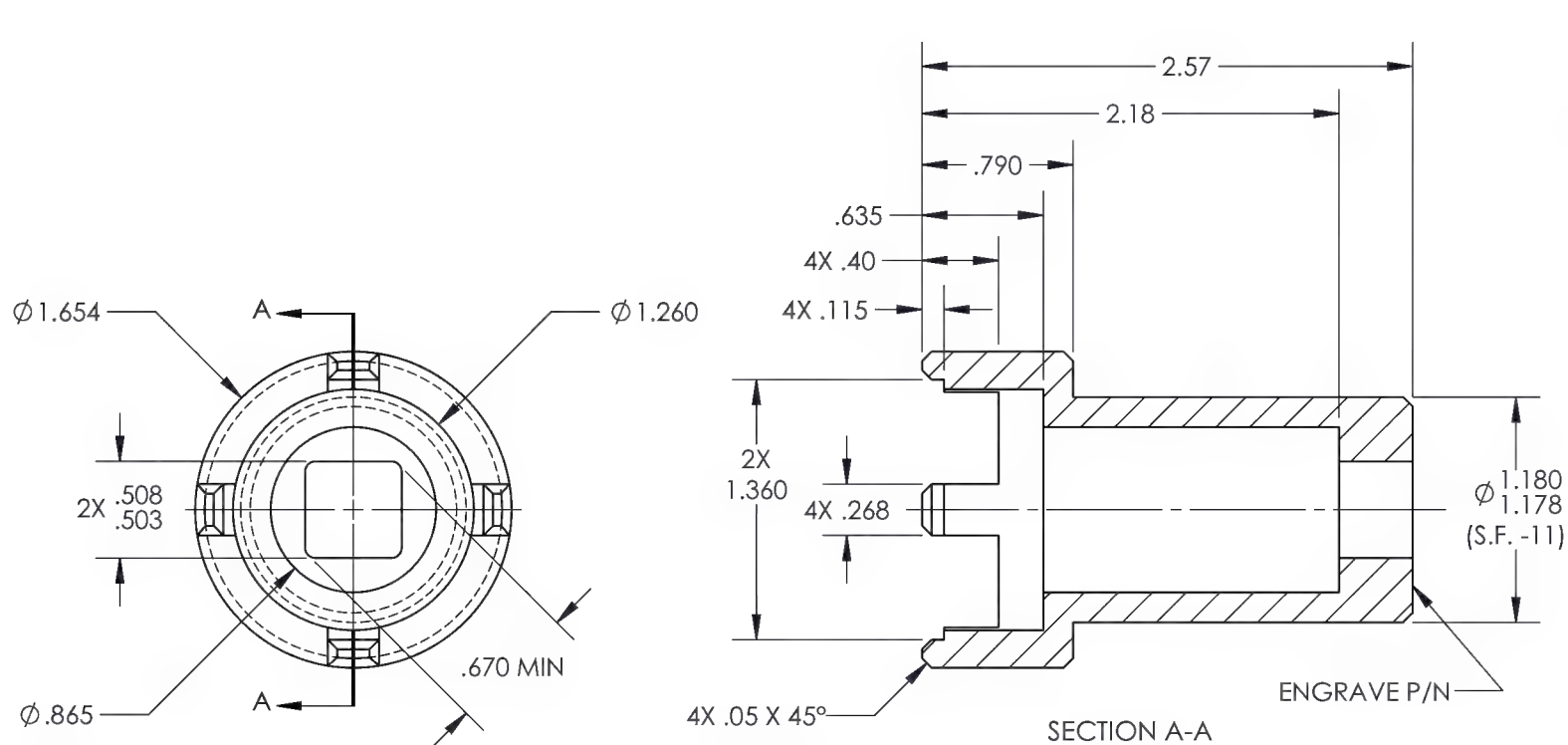


(-31)
RING

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-31	REV 2
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC MIL-A-8625, TYPE II, CLASS I	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: DUERFELDT	.X \pm .1 SURFACES = 125/✓
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 12/7/2015
	SHEET 17 OF 22

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-33 CH'D DIM WAS Ø1.18 IS Ø1.180/1.178 (S.F. -11), ADDED HEAT TREAT RC 28-32.	10/20/2016	RJC	SM

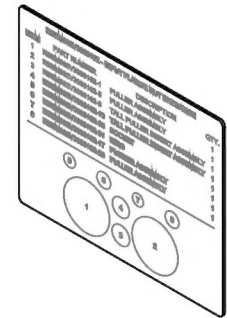
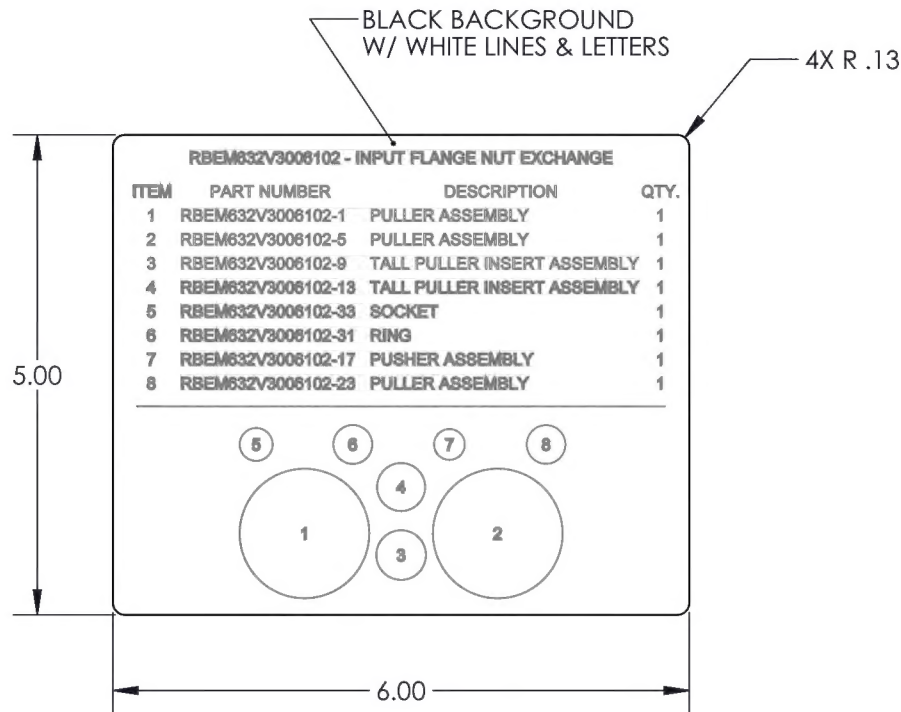


(-33)
SOCKET

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-33	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 12/7/2015	USED ON MODEL
SHEET 18 OF 22	H175

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



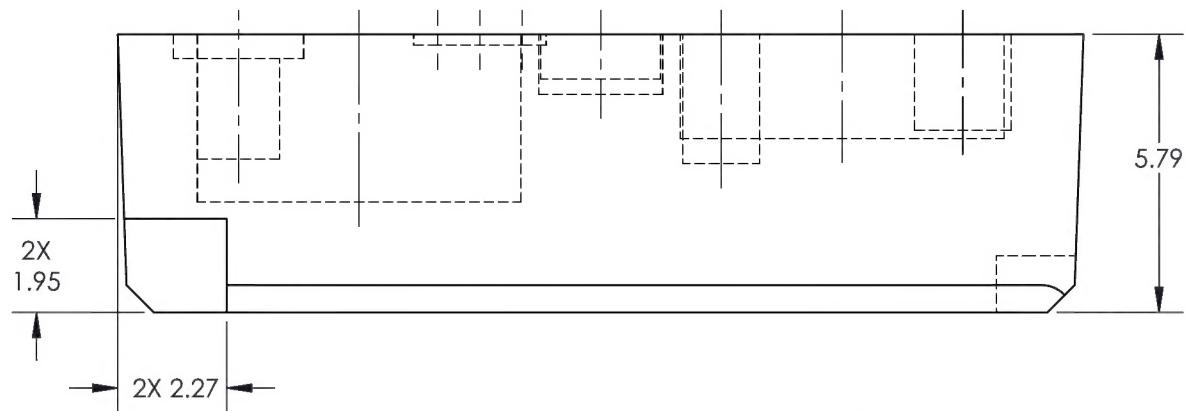
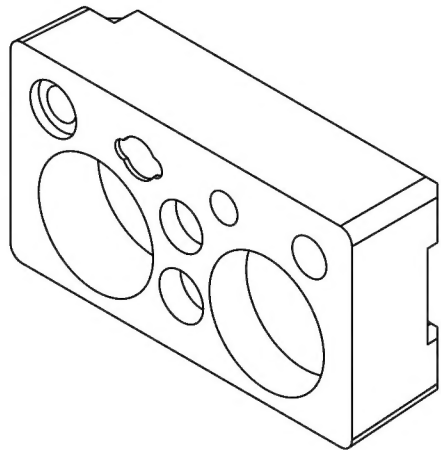
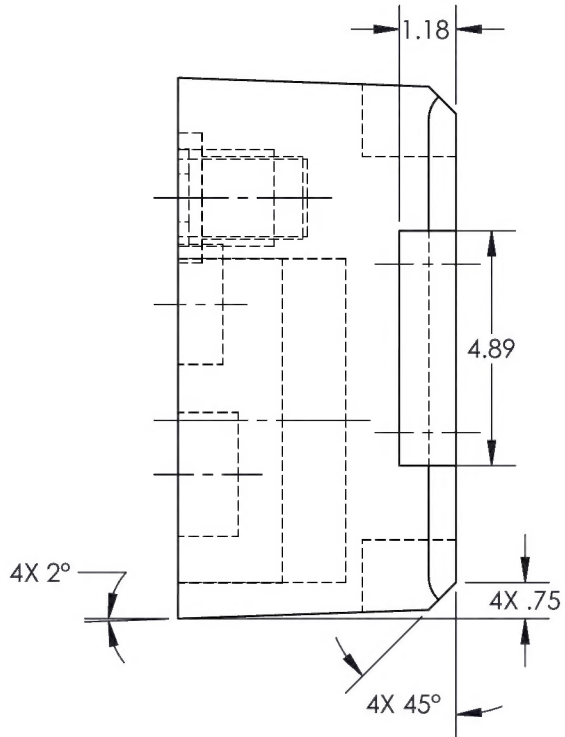
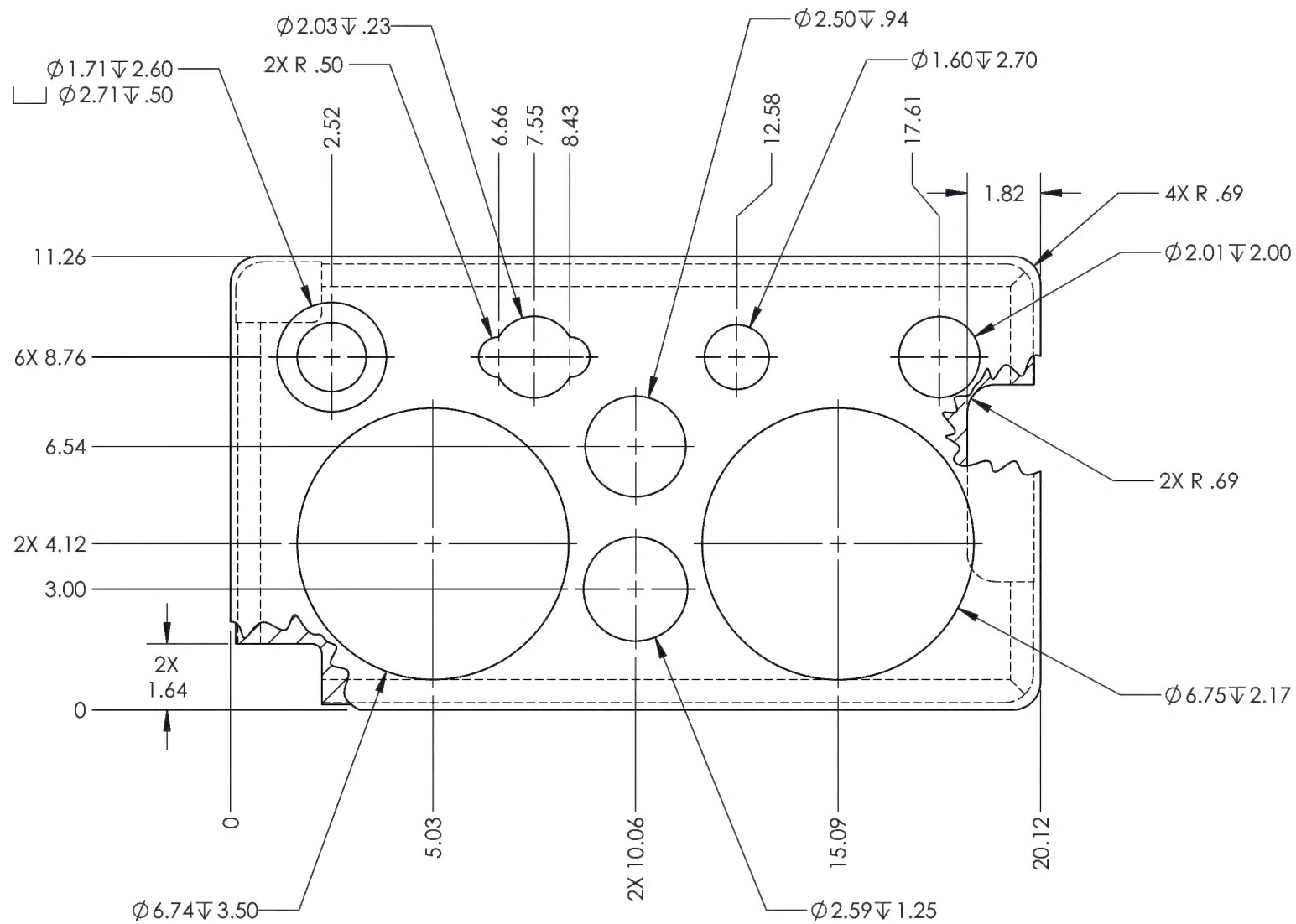
(-35)

CONTENTS PLACARD

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-35	REV ?
MAT'L PLASTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/1/2015
SHEET 19 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-37 CH'D MATERIAL & VENDOR WAS Y20 BLACK (I.R. SPECIALTY) IS ETHAFOAM 220, BLACK (CASE SOLUTIONS), DELETED DIM 4X R.69 ADDED DIM'S 4X 45°, 4X .75.	10/20/2016	RJC	SM



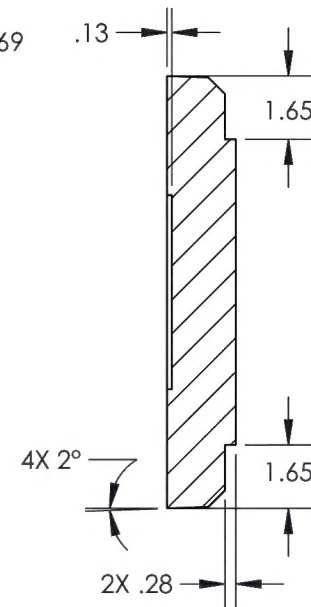
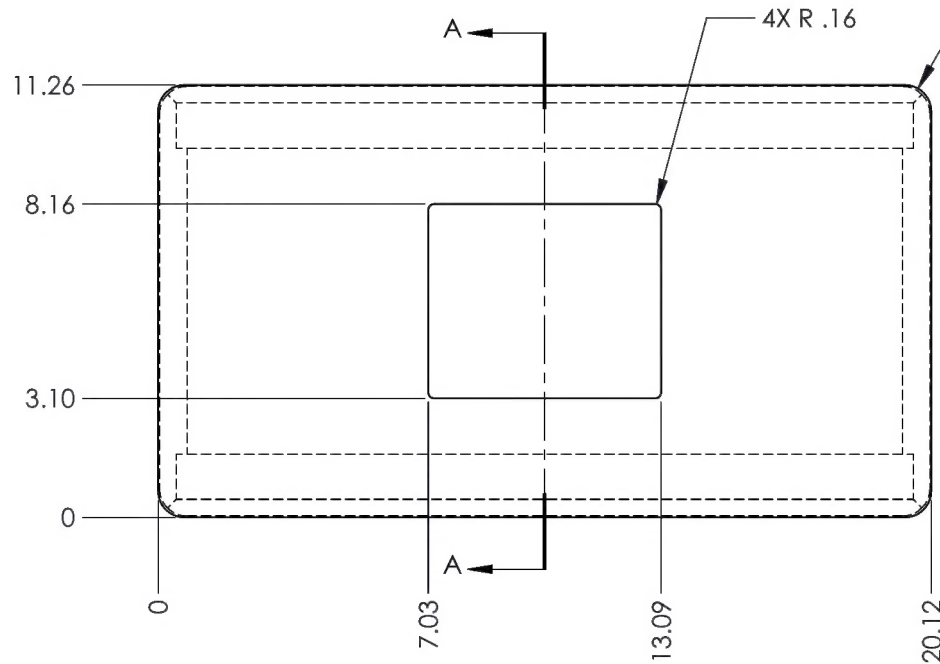
(-37)

BOTTOM TOOL CUSHION

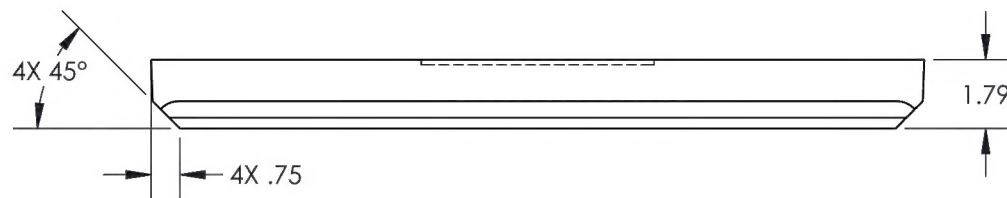
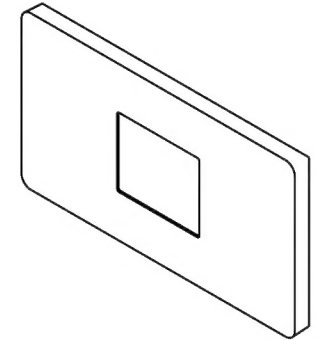
DART AEROSPACE			
TITLE SWASHPLATE LIFT SLING			
DWG NO. RBEM632V3006102-37			REV 2
MAT'L ETHAFOAM 220, BLACK		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX \pm .010 FRACTIONS \pm 1/8	
FINISH		.XX \pm .03 ANGLES \pm 1°	
SPEC		.X \pm .1 SURFACES = 125✓	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE 1:4		DATE 12/7/2015	SHEET 20 OF 22

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0181	-39 DELETED DIM 4X R.69, ADDED DIM'S 4X .75, 4X 45°, 2X .28, 1.65. CH'D MATERIAL & VENDOR WAS Y20 BLACK (I.R. SPECIALTY) IS ETHAFOAM 220, BLACK (CASE SOLUTIONS).	10/20/2016	RJC	SM



SECTION A-A



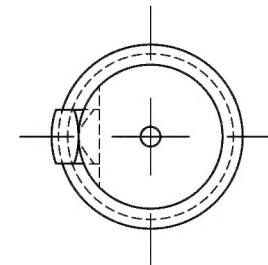
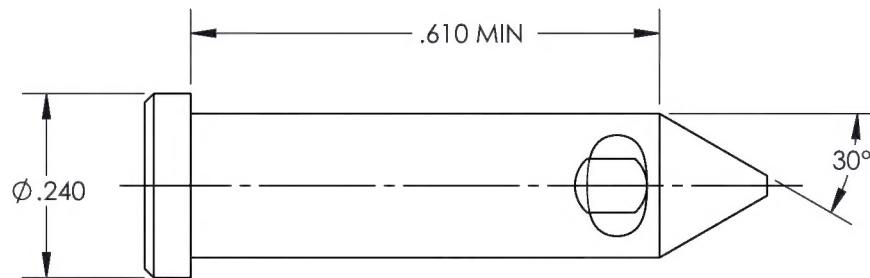
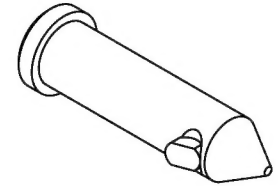
(-39)

TOP TOOL CUSHION

DART AEROSPACE	
TITLE SWASHPLATE LIFT SLING	
DWG NO. RBE632V3006102-39	REV 2
MAT'L ETHAFOAM 220, BLACK	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
FEAT TREAT FINISH	.XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓
SPEC	
DRAWN BY:	DUERFELDT
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL H175	
SCALE 1:5	DATE 12/7/2015
SHEET 21 OF 22	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-011	-51 ADDED DRAWING FOR MODIFIED BUYOUT.	10/21/2016	RJC	SM



(-51)

CLEVIS PIN

DART AEROSPACE	
TITLE INPUT FLANGE NUT EXCHANGE	
DWG NO. RBEM632V3006102-51	REV 2
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 4:1	DATE 8/15/2016
SHEET 22 OF 22	